

Date: Wednesday, 9/24/2008 9:54:22 AM  
 User: David Duval

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEARPLATE ASSEMBLY
Job Number : 05039	
Estimate Number : 13488	
P.O. Number :	Part Number : D3805041
This Issue : 9/24/2008 S.O. No. :	Drawing Number : D3805 PROTO
Prsht Rev. : NC	Project Number : N/A
First Issue : 9/24/2008 Type : R & D LG FAB	Drawing Revision : PROTO
Previous Run : 05035	Material :
Written By : <u>MS 08/09/24</u>	Due Date : 10/1/2008 Qty: 1 Um: Each
Checked & Approved By :	
Comment : Est Rev:A 08-07-21 new issue DD verified by:EC	

## Additional Product

Job Number:



*SCRAP*

**PROTOTYPE**

**FOR ENGINEERING USE ONLY**

Seq. #:	Machine Or Operation:	Description :
1.0	D38051	Fwd Plate
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Fwd Plate batch:		
2.0	D38061	Bar
Comment: Qty.: <del>4.0000</del> 1 Each(s)/Unit Total : 4.0000 Each(s) <i>CP 08.05.29</i> Bar batch:		
3.0	D38063	Bar
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Bar batch:		
4.0	D38065	Bar
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Bar batch: <i>NIA CP 08.05.29</i>		
5.0	D38067	Bar
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Bar batch: <i>NIA CP 08.05.29</i>		

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Job Number: 05039

Part Number: D3805041

Job Number:



Seq. #: Machine Or Operation: Description :

6.0

D38069

Bar



Comment: Qty.: 1.0000 f(s)/Unit Total: 1.0000 f(s)  
Bar  
batch:

N/A

9/28.09.24

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

2- position D3806-1, -3, -5, -7 and -9 bars to plates and weld as per dwg D3805 (SEE NOTE 9)

304 S.S. Welding Rod

BATCH #: M106115

Fill cut outs with Hardcoat welding rod on D3806-1 and -3

1- weld hardcoat, 0.188" thick X 0.500 wide, flush with D3806-X bars as per dwg D3805 (SEE NOTE 10)

2059 B Hardcoat Welding Rod

BATCH#: M109303

FL 8-10-20

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

08/10/21 (1)

9.0

QC5

INSPECT WORK TO CURRENT STEP



ENGINEERING  
APPROVAL



Comment: INSPECT WORK TO CURRENT STEP

\* Scrap due to redesign

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME: \_\_\_\_\_

OVEN TEMPERATURE: \_\_\_\_\_

FINISH TIME: \_\_\_\_\_

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

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Job Number: 05039

Part Number: D3805041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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12.0	D38071	Gasket
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Gasket  
batch: \_\_\_\_\_

13.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1  
1- Bond D3807-1 gasket to inner surface of wearplate D3805-1 using contact cement  
A/R Contact cement : \_\_\_\_\_

14.0	QC5	INSPECT WORK TO CURRENT STEP
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**ENGINEERING  
APPROVAL**

Comment: INSPECT WORK TO CURRENT STEP

15.0	PACKAGING 1	PACKAGING RESOURCE #1
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**FOR ENGINEERING USE ONLY**

Comment: PACKAGING RESOURCE #1  
Identify and Stock  
Location: \_\_\_\_\_

16.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



Change to W/O # 00255A

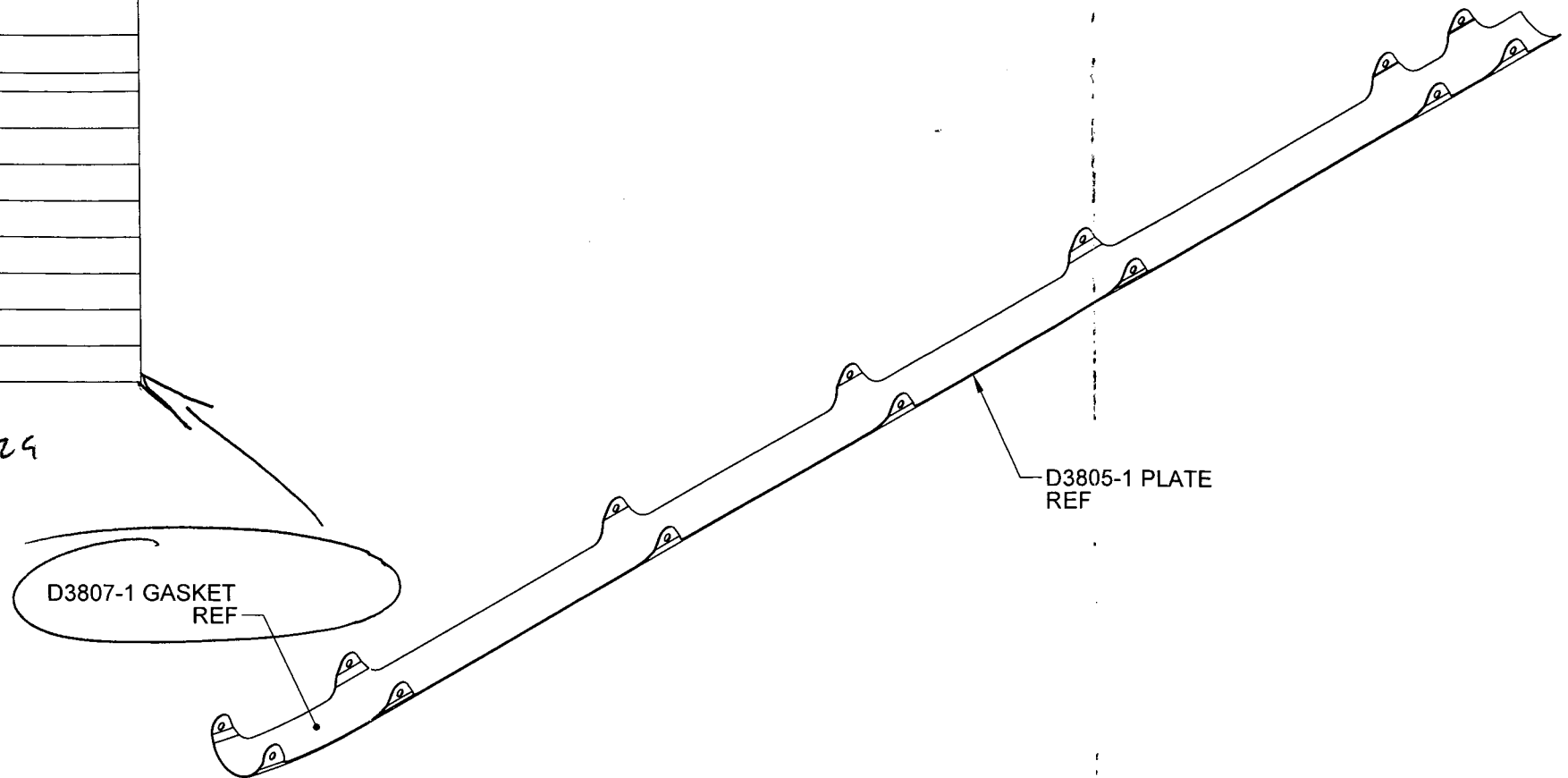
MF

08-12-05

# PARTS LIST

QTY -041	PART NUMBER	DESCRIPTION
X	D3805-041	WEARPLATE ASSEMBLY
1	D3805-1	PLATE
# 1	D3806-1	BAR
1	D3806-3	BAR
1	D3806-5	BAR N/A
1	D3806-7	BAR N/A
1	D3806-9	BAR N/A
A/R	7580 2059 B	HARDCOAT WELD
A/R	N/A	CONTACT CEMENT

1 D3807-1 GASKET 908.09.24

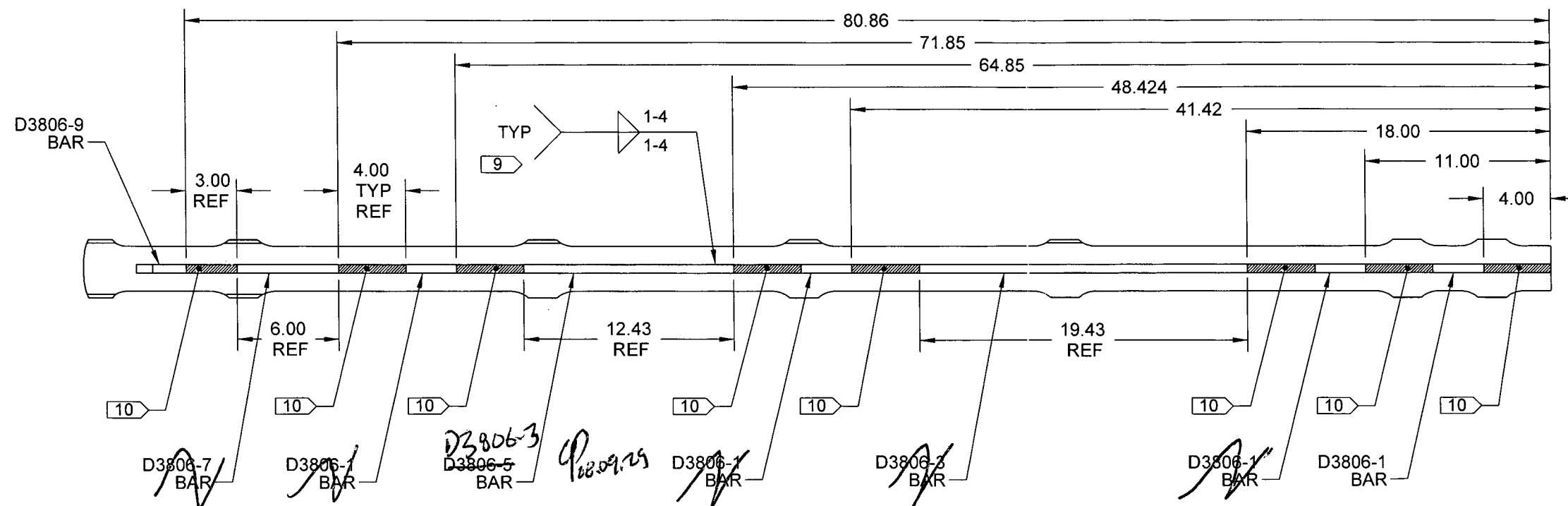
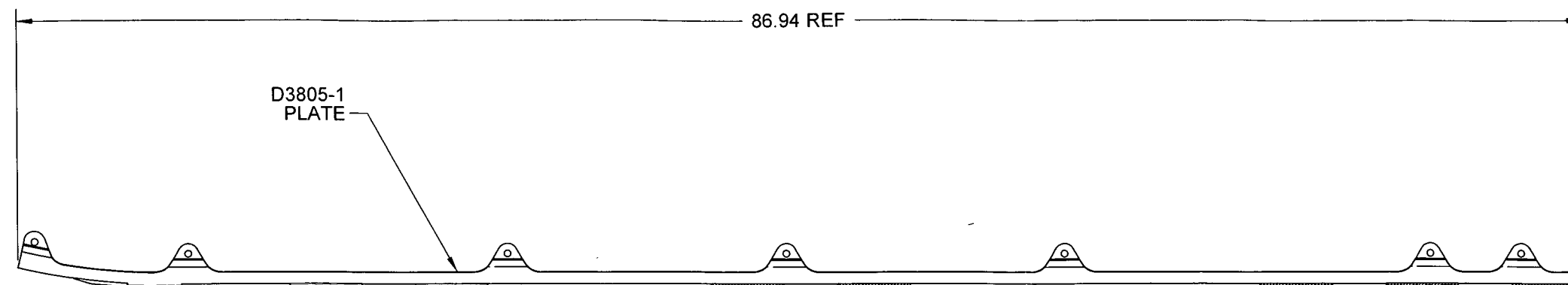


**D3805-041 WEARPLATE ASSEMBLY**

**PROTOTYPE**  
PLEASE RETURN ALL ISSUED  
DATA TO ENGINEERING  
08.09.22

A	NEW ISSUE	CP	08.09.18
REV.	DESCRIPTION	BY	DATE
DESIGN		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3805	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSEMBLY	NTS
DATE	08.09.18	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD  THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS  NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT  WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1



**D3805-041 WEARPLATE ASSEMBLY**

**PROTOTYPE**  
PLEASE RETURN ALL ISSUED  
DATA TO ENGINEERING  
*[Signature]* 08.09.18

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3805-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 5.77 lbs
- 8) WELD PER QSI 004
- 9) WELD D3806-X BARS USING 1.00 LONG WELDS WITH 4.00 PITCH, STAGGER WELD PATTERN ON EITHER SIDE OF BARS
- 10) 7660 HARDCOAT WELD, 0.188 THICK x 0.500 WIDE, FLUSH WITH D3806-X BARS
- 11) BOND D3807-1 GASKET TO INNER SURFACE OF WEARPLATE USING A LAYER OF CONTACT CEMENT

2059 B Hardcoating

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		<b>D3805</b>	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		<b>WEARPLATE ASSEMBLY</b>	NTS
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8 7 6 5 4 3 2 1

# PROTOTYPE REQUEST FORM

DART Aerospace Ltd.

Product #: WEARPLATE

Job #: 00255A

Date: 08.09.19

Product Name: D206-642

Requested By: CP

Design Manager Approval: 

Quantity	Part Number	Category	Description	Drawing Date	Material Cert Req'd?	Due Date	Comments	Date Completed
1	D3805-1	SF	<sup>4005</sup> PLATE	08.09.18	N	08.09.26	CONCEPTUAL PROTO, TO CHECK BENDING	
4	D3806-1	SF	<del>4005</del> BAR	08.09.18	N	08.09.26		
1	D3806-3	SF	<sup>40676</sup> BAR	08.09.18	N	08.09.26		
1	D3806-5	SF	BAR	08.09.18	N	08.09.26		
1	D3806-7	SF	BAR	08.09.18	N	08.09.26		
1	D3806-9	SF	BAR	08.09.18	N	08.09.26		
1	D3805-041	SF	<sup>05035</sup> WEARPLATE	08.09.18	N	08.09.26	MADE FROM ABOVE PIECES	